

128814

Tuesday, January 27, 2015 7:48:42 AM

N900040100

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

40

Customer:

Run Start *NR1*

Tooling:

Date:

Stop ***NB2***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Draw Nbr	Revision Nbr
D2873	Rev A

BAND SAW

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

110

HAAS CNC VERTICAL MACHINING #1

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3
Dwg Rev A Folio Rev AA

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128814

Tuesday, January 27, 2015 7:48:42 AM

128814

Page 2

Item ID: D2873-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 1/26/15 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Deburr 2- C'sink as per Dwg D2873								
150	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
150									
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

FFR 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Tuesday, January 27, 2015 7:48:42 AM

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DAS
36
9-89

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Page 4

Stop *NR2*

0.00

DAE
38
9-8

MAR 10 2015

MF 15-3-10

MLS 1503-11

me

15-3-10

DQA: _____ Date: _____



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Picklist Print

Tuesday, January 27, 2015 7:48:41 AM

Page 1

Work Order ID: 128814

128814

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	20.4000	0.3083	12.98105			

M6061T6B0.375X01.000

6061T6 BAR .375 x 1.00

Location

Loc Qty

Loc Code

MAT001 131392
m131226

20.4
20.4

180 Each

1,890.000

6

240

14.281

JFK 2015-02-04

MS20426AD4-6

Purchased

No

MS20426AD4-6

Rivet

Location

Loc Qty

Loc Code

GA
M128812
MF4
124392
ST312
124392
M128812

904
904
185
185
801
83
718

100 Each

449.0000

3

120

M130922

24002

MS21075L5

Purchased

No

MS21075L5

Nut Plate

Location

Loc Qty

Loc Code

GA
m128578
ST273A
m128578
ST300
123346

7
7
435
435
7
7

112

8

DAS
36
9-89

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order: 128814
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

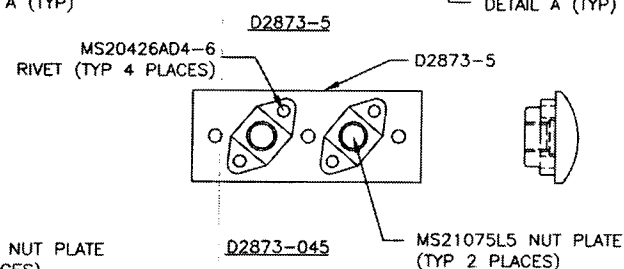
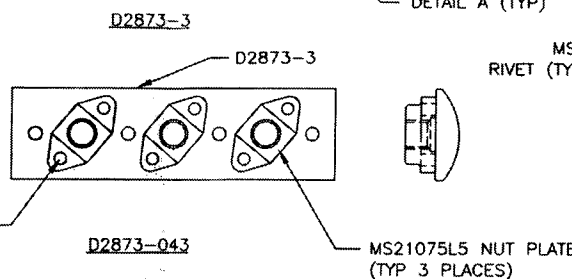
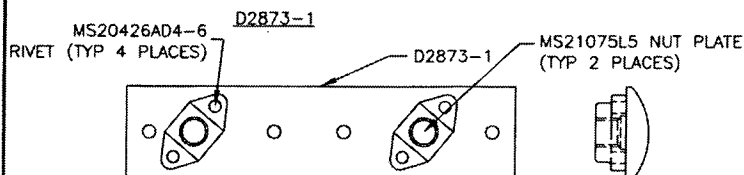
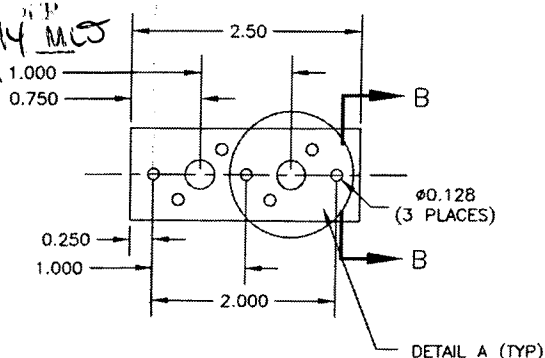
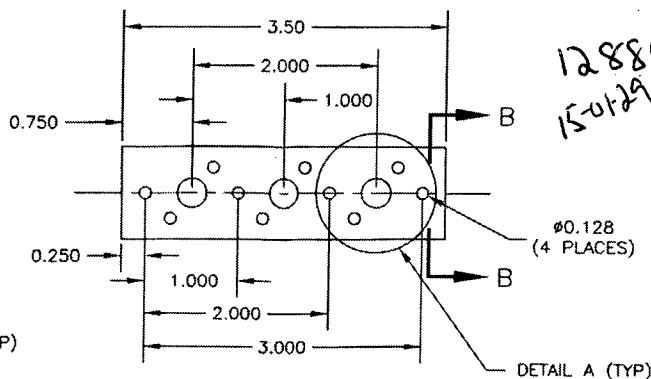
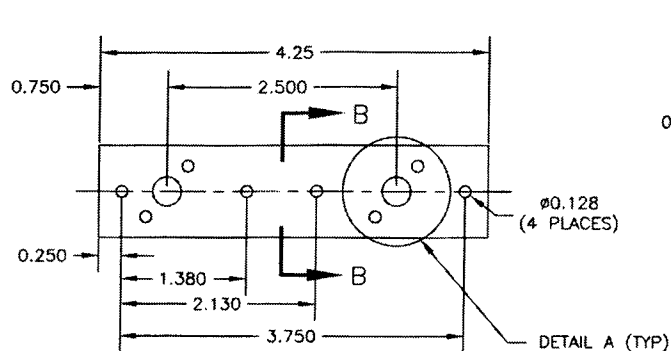
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓		6" Vern	BC 05
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	.750	✓			
1.000	+/-0.010	.999	✓			
0.250	+/-0.010	.245	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	.131	✓			
0.359	+/-0.010	.359	✓			
Ø0.316	+0.006/-0.001	.318	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.252	✓			
0.061	+/-0.010	.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.229	✓			

Measured by: BC / [Signature]	Audited by: DAS	Prototype Approval:	N/A
Date: 15-02-06	Date: 15/02/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	[Signature]

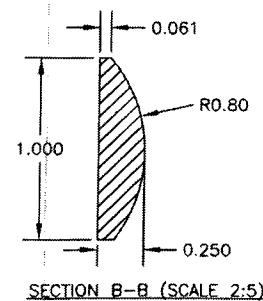
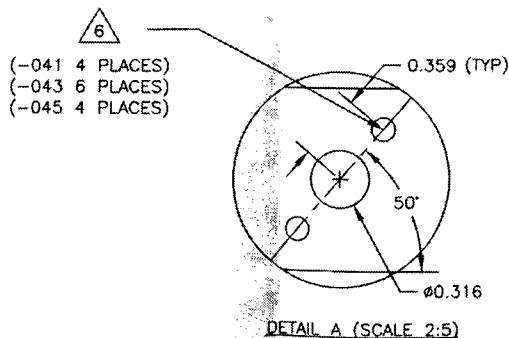
COPY



- D2873-1/-3/-5 RADIUS BLOCK**
- MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
 - FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - ALL DIMENSIONS ARE INCHES
 - BREAK ALL SHARP EDGES 0.010 TO 0.020
 - Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100"
- D2873-041/-043/-045 NUT PLATE ASSEMBLY**
- INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5